

Date: Wednesday, 6/6/2007 3:45:53 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM  
 Job Number : 32840  
 Estimate Number : 10493  
 P.O. Number : N/A Part Number : D32043  
 This Issue : 6/6/2007 S.O. No. : N/A Drawing Number : D3204 REV: A1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A1  
 Previous Run : 30895 Material : N/A  
 Due Date : 6/27/2007 Qty: 6 Um: Each  
 Written By :  
 Checked & Approved By : 0706.07  
 Comment : Est:C 05.08.11 Added Step 25 KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X02000 6061-T6 Bar .50" x 2.0"



Comment: Qty.: 0.5815 f(s)/Unit Total : 3.4889 f(s)

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8)  
 (M6061T6B0.500x02.000)

Batch: 7103755

ml 07/08/28

6

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000)

ml 07/08/28

6

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA344 and Dwg D3204

2- Deburr

Identify as D3204-3

ml 07/08/28

6

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07/08/28

6

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SG 07-08-28

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/08/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32840

Part Number: D32043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*EP 07/08/29 (6)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*D 07/08/29 (6)*

Job Completion



*U 07/08/29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 32840
<b>Description:</b> Arm		<b>Part Number:</b> D3204-3
<b>Inspection Dwg:</b> D3204 <b>Rev:</b> A1		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                         
 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.00	+/-0.030	5.990	—			
5.25	+/-0.030	5.250	—			
0.776	+/-0.010	0.778	—			
Ø0.760	+0.005/-0.000	Ø0.761	—			
0.080	+/-0.010	0.079	—			
R0.50	+/-0.010	R0.50	—			
2.373	+/-0.010	2.372	—			
0.750	+/-0.010	0.749	—			
R0.380	+/-0.010	R0.380	—			
Ø0.375	+0.001/-0.000	Ø0.375	—			
0.300	+/-0.010	0.298	—			

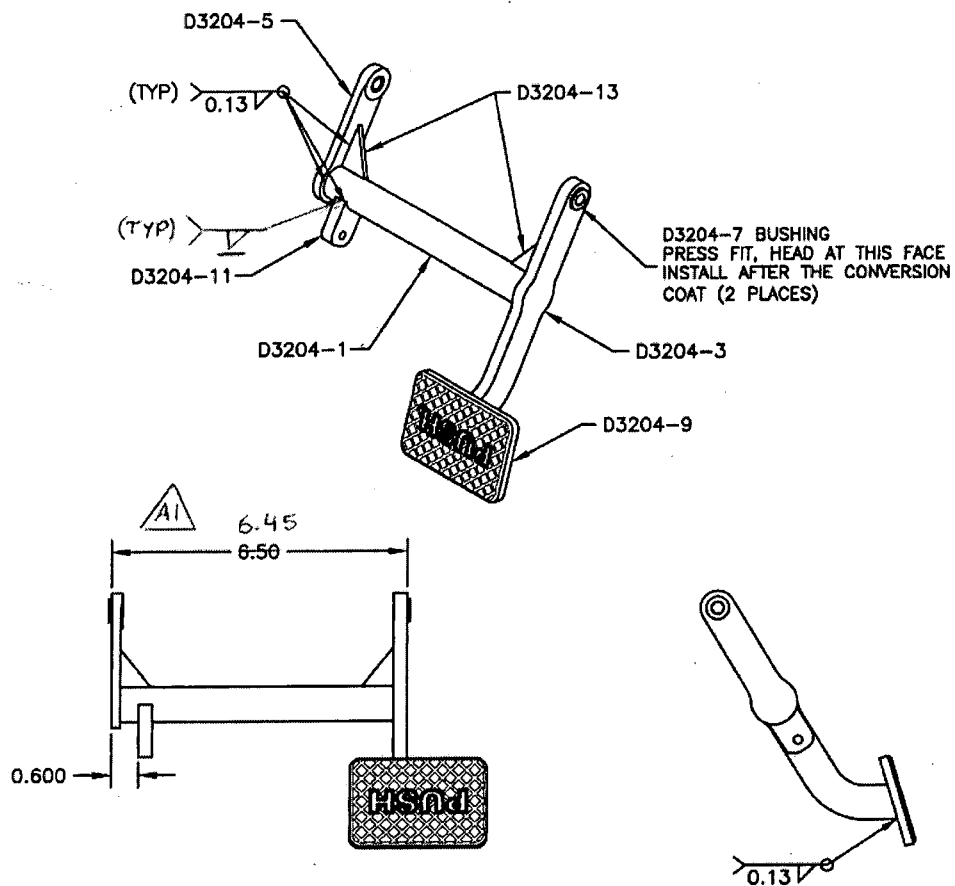
<b>Measured by:</b> <i>[Signature]</i>	<b>Audited by:</b> <i>[Signature]</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/08/28	<b>Date:</b> 07.08.28	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	06.03.21	Dwg Rev update	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED  
04.04.30



**D3204-041 RELEASE PEDAL ASSEMBLY**

**NOTES**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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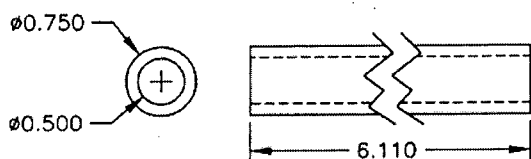
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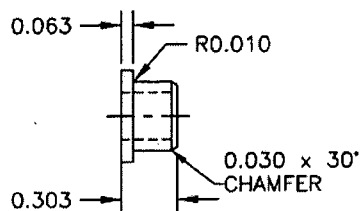


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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

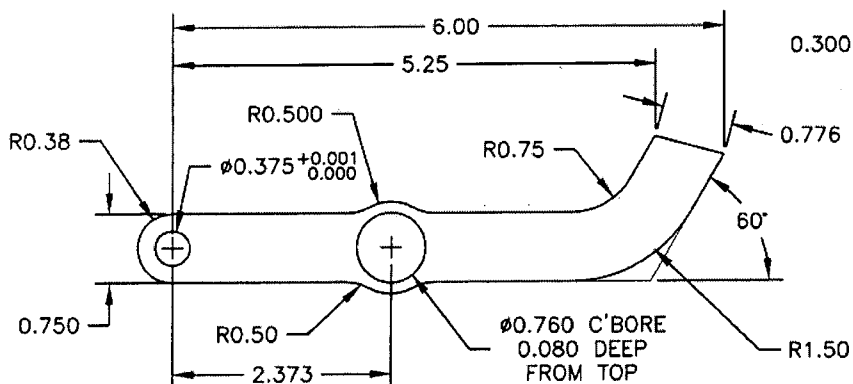
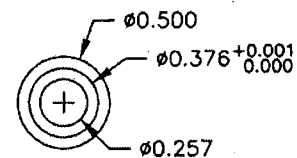
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04.04.05 [Signature]



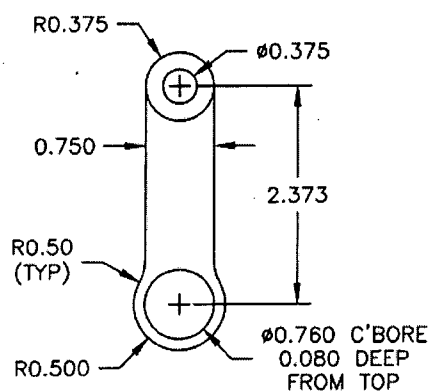
2 D3204-1 TUBE  
SCALE 1:2



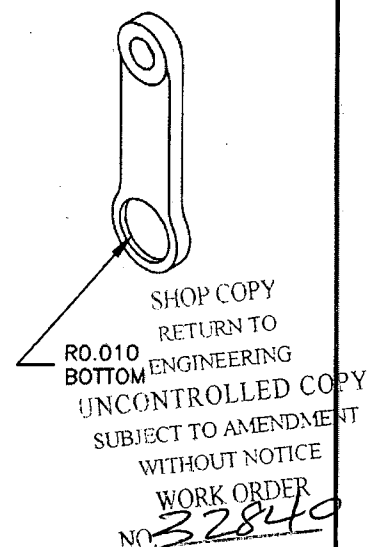
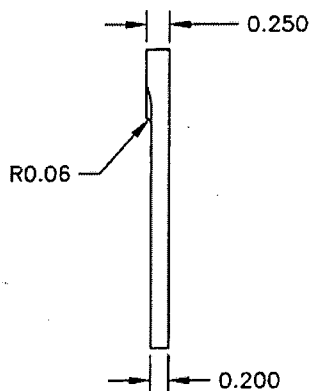
4 D3204-7 BUSHING  
SCALE 1:1



3 D3204-3 ARM  
SCALE 1:2



3 D3204-5 ARM  
SCALE 1:2



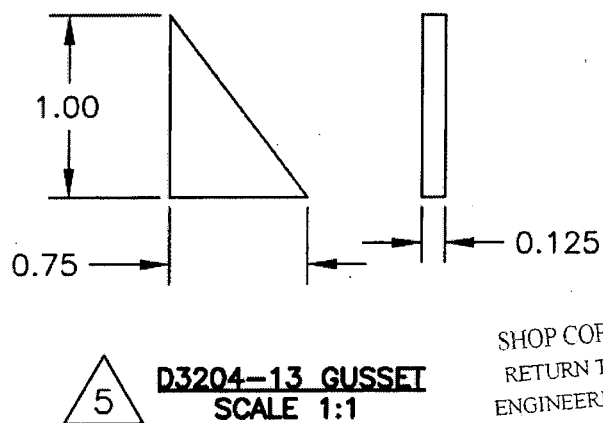
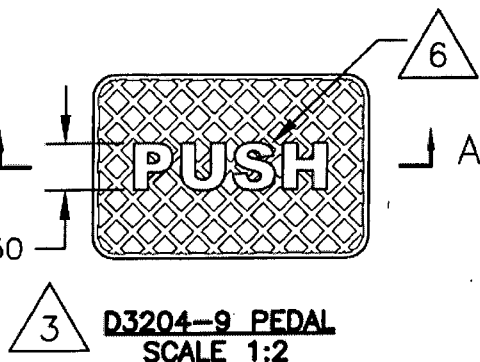
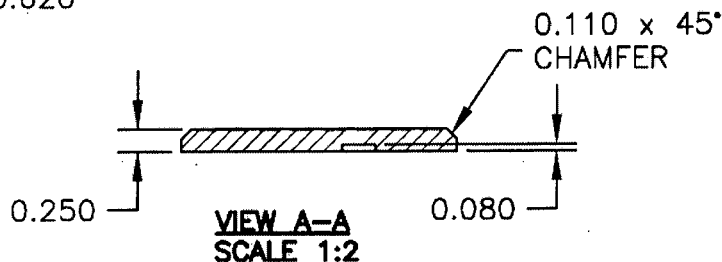
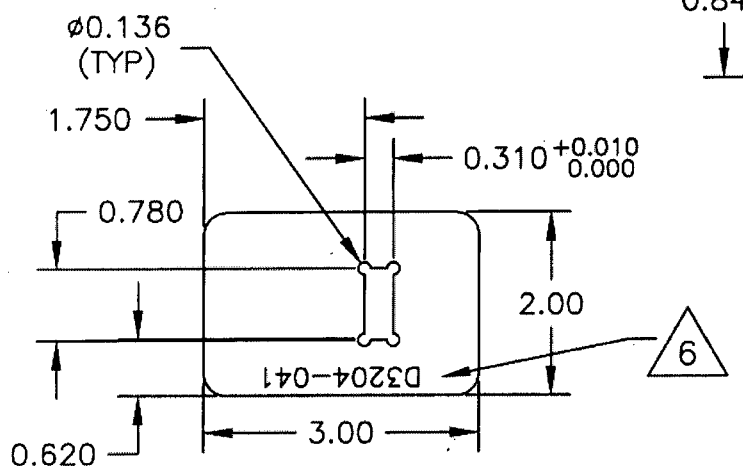
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DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS

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04.09.30



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